

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001421**Date Inspected:** 09-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Shen Xue Jun			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	SAS superstructure		

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector Joe Lanz arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions during second shift. While on site the QA Inspector observed and/or discovered the following.

Bay 1

OBG Deck

The QA inspector periodically observed the in process drilling and chamfering of deck closed rib holes in piece marks U-203, U-204, U-205 and U-206. The drilling of the closed ribs was performed by four ZPMC personnel using magnetic base portable drills. The work was not completed on this date and appears to meet the minimum requirements of the contract documents.

New Tower Shop

89 Meter Mockup diaphragms, MU58-MA-27:

The QA inspector observed ZPMC personnel performing the fit up of the corner stiffener piece mark MUSB-SA194 as shown on drawing MUB-MA-21. Five ZPMC personnel were in process of installing the corner stiffener inside of the Mockup diaphragms. The work was not completed on this date.

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Cutting Facility

The QA inspector periodically observed two ZPMC personnel cutting diaphragm plates, piece mark P778-1 and P1424-1 from 75mm thick plate marked A709M HPS 485WT2. The cutting was performed using automatic oxygen fuel gas equipment. After the cutting was complete the cut edges were ground to remove slag and notches.

The work was not completed on this date and appears to meet the minimum requirements of the contract documents. The previously cut plate was stored on wood dunnage and appeared to be properly marked in accordance with contract requirements.

The QA inspector observed that completed floor plates for the orthotropic box girders were stored immediately outside the cutting facility. The floor beams were stored off the ground on wood and were covered with tarps.

Summary of Conversations:

No relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
